



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3121-144
Job Sheet 169025



Part No: D3121-144

Job Qty: 4 ea

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/29/17

Job Tracking No:

Due Date: 12/18/17

Created By: Linda Lacelle

Type: SOLD

Description:

Customer: Black Tusk Helicopters Ltd (CBLAC03)

PO Box 1469, 46041 Government Road Squamish, BC, V8B 0B1 Canada ph:(604) 898-4800

Note: DWG REV E IPP Rev:Pick:A 04.02.18 New issue KJ/DS IPP Rev:B ECN 1060 07-11-12 DD verified by:EC IPP
Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		12/15/17	0.00	0.00	Start Up Machining-1		<i>[Signature]</i>
100	Bandsaw	4 pcs		12/15/17	0.00	1.56	Bandsaw1		<i>[Signature]</i>
110	CNC Vertical Machining	4 pcs		12/16/17	0.36	8.51	HAAS1-3		<i>[Signature]</i>
120	QC	4 pcs		12/16/17	0.00	0.00	QC2 Machining-1		<i>[Signature]</i>
130	QC	4 pcs		12/16/17	0.00	0.00	QC8 Machining-1		<i>[Signature]</i> 14-12-15
140	Small Fab	4 pcs		12/18/17	0.00	0.22	Small Fab-2		<i>[Signature]</i> DAS
150	QC	4 pcs		12/18/17	0.00	0.00	QC5		<i>[Signature]</i> 38
160	Packaging	4 pcs		12/18/17	0.00	0.00	Packaging3-1	5/018	<i>[Signature]</i> 9-00
170	QC21-SA	4 Ea		12/18/17	0.00	0.00	QC21		<i>[Signature]</i>

Part Op 100 - Cut blanks: (1.250" x 2.000") 4.425" long

Descriptions: 110 - 1-Machine D3121-114 as per Folio FA330 and Dwg D3121 Identify as D3121-114

140 - Assemble D3121-143 as per Dwg D3121.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D3121-241 5024941 2x	8	25	0	0
140-Small Fab	D3121-215000786	8	52	0	0
	M17-4-B1.250X02.000	1	9	0	0

Part Specifications

Specifications could not be found.

Plex 11/29/17 12:58 PM dart.lacelle.linda

DART
AEROSPACE
S019550

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Bracket Assembly

PART NO: D3121-144

Revision:

Operation:

Change No:

Start up Operation

Mfg Date: 12/11/17

Job No: 169025

DART AEROSPACE LTD		Work Order: 169025
Description: Bracket		Part Number: D3121-114
Inspection Dwg: D3121	Rev: E	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.080	+/-0.010	.080	/		Vern M/L-08	
0.300	+/-0.010	.300	/		"	
R0.375	+/-0.010	R.375	/		R-G	
1.54	+/-0.030	1.542	/		Vern M/L-08	
0.350	+/-0.010	.350	/		"	
R0.25	+/-0.030	R.250	/		R-G	
Ø0.392	+0.002/-0.000	Ø.3935	/		Vern M/L-08	
Ø0.201	+/-0.010	Ø.197	/		"	
0.100	+/-0.010	.097	/		"	
2.540	+/-0.010	2.538	/		"	
1.590	+/-0.010	1.588	/		"	
0.160	+/-0.010	.159	/		"	
0.400	+/-0.010	.400	/		"	
1.220	+/-0.010	1.220	/		"	
1.600	+/-0.010	1.607	/		"	
3.80	+/-0.030	3.800	/		"	
1.800	+/-0.010	1.803	/		"	
R0.50	+/-0.030	R.500	/		R-G	
0.130	+/-0.010	.129	/		Vern M/L-08	
3.41	+/-0.030	3.390	/		"	
3.65	+/-0.030	3.628	/		"	
2.24	+/-0.030	2.210	/		"	
45°	+/-0.1°	45°	/		"	
R0.25	+/-0.030	R.250	/		"	
3.97	+/-0.030	3.972	/		"	
R0.38	+/-0.030	R.380	/		R-G	
Ø0.392	+0.002/-0.000	Ø.3933	/		Micro	
Ø0.201	+/-0.010	.197	/		Vern M/L-08	
0.268	+/-0.010	.268	/		"	
R0.260	+/-0.010	.265	/		"	
0.080	+/-0.010	.080	/		"	
0.300	+/-0.010	.300	/		"	
0.381	+/-0.010	.386	/		"	
0.201	+/-0.010	.200	/		"	
0.580	+/-0.010	.587	/		"	

